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DART AEROSPACE LTD			Work Order:	21581																																																			
Description: Bearpaw Kit (19" x 24")			Part Number:	K10008																																																			
Dwg: D2432 Rev. F3			Qty:	20 Kits																																																			
Ref: K10008 Rev. E; DSK086-5 Rev. A				Page 1 of 1																																																			
Step	Location	Procedure	By	Date	Qty																																																		
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	JK	04.09.23	20																																																		
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	JK Wk 42 JK JK	04.10.12	20																																																		
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15411	JK	04/10/20	20																																																		
4	MV	Inspect material for defects or damage prior to machining	JK	04/10/20	20																																																		
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	JK	04/10/20	20																																																		
6	QC2	Inspect parts as they come off the CNC machine	JK	04/10/20	20																																																		
7	MV	Deburr	JK	04/10/20	20																																																		
8	QC8 & 5	Second inspection	EP	04/10/20	20																																																		
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table border="1"> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21185</td></tr> <tr> <td>12</td><td>D2274</td><td>Radius Block</td><td>B21188</td></tr> <tr> <td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B21581</td></tr> <tr> <td>6</td><td>D2438</td><td>Clamp</td><td>B21189/B20963B</td></tr> <tr> <td>12</td><td>D2529</td><td>Washer</td><td>B20964B/B20388</td></tr> <tr> <td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr> <tr> <td>12</td><td>AN4-15A</td><td>Bolt</td><td>m1532/m14544</td></tr> <tr> <td>12</td><td>AN4-17A</td><td>Bolt</td><td>m14520/m14311</td></tr> <tr> <td>24</td><td>AN960JD416</td><td>Washer</td><td>m15020/m15321</td></tr> <tr> <td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m15020</td></tr> <tr> <td>1</td><td colspan="3">Paperwork package from Step 2</td><td>CD</td><td>04/10/21</td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B21185	12	D2274	Radius Block	B21188	2	D2432F	24" Bearpaw	B21581	6	D2438	Clamp	B21189/B20963B	12	D2529	Washer	B20964B/B20388	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	m1532/m14544	12	AN4-17A	Bolt	m14520/m14311	24	AN960JD416	Washer	m15020/m15321	12	MS21042L4	Nut (or -4)	m15020	1	Paperwork package from Step 2			CD	04/10/21	CD	04/10/21	20
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10	QC4	Inspect Kit for 100% Completeness on the W/O	JK	04/10/26	20																																																		
11	PK	Identify and pack for shipping as per PPP K10008 Rev: E	JK	04-10-26	20																																																		
12	AC	Cost / part 218.49	JK	04.10.27	20																																																		
13	DC	Close W/O 218.51 Inspect Level 21	JK	04.10.27	20																																																		

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	#

BS 04.10.27

RELEASED
04.02.20

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____

Date: _____

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	21581
Description: Bearpaw	Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.060 x 45°	—		U-earm	
B 5.500	+/-0.030	5.505	✓		U-earm	
C 0.200	+/-0.030	0.202	—		U-earm	
D 0.25 x 45°	+/-0.030	0.235 x 45°	—		U-earm	
E R0.250	+/-0.030	R0.250	✓		R-6	
F 0.250	+/-0.010	0.256	—		U-earm	
G 0.625	+/-0.030	0.633	—		U-earm	
H 0.375	+/-0.010	0.383	✓		U-earm	
I 0.950	+0.030/0.010	0.946	✓		U-earm	
J 19.000	+/-0.030	19.006	—		M-Tape	
K 3.14	+/-0.030	3.110	✓		U-earm	
L 3.28	+/-0.030	3.289	✓		U-earm	
M Ø0.260	+0.005/-0.000	Ø0.260	✓		U-earm	
N Ø0.93	+/-0.030	Ø0.927	—		U-earm	
O 0.30	+0.030/-0.000	0.310	—		U-earm	
P 23.750	+/-0.030	23.750	✓		M-Tape	
Q 7.375	+/-0.030	7.375	✓		M-Tape	
R 4.250	+/-0.010	4.250	✓		U-earm	
S 2.000	+/-0.030	2.000	—		U-earm	
T 9.000	+/-0.010	9.000	✓		M-Tape	
U 9.000	+/-0.010	9.000	✓		M-Tape	
V 0.375	+/-0.010	0.380	—		U-earm	

Measured by:	<u>anl</u>	Audited by:	<u>EC</u>	Prototype Approval:	N/A
Date:	04/10/20	Date:	04.10.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/o K10008/D206-559-015	KJ/RF

RELEASED

42 04.01.15

Job Costing Report

Dart Aerospace Ltd.
HawkesburySep 23, 2004
10:35 am

Work Order No : 0021581
 Project Name : K10008
 Project For : WK444
 Work Order Type : Main
 Main WO Number :
 House Part-Number : *K10008
 Description : Bearpaw kit 19" x 24"
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 09-23-04
 Est Finish Date : 10-30-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00